



Process Hazard Analysis for 2015
 Report of Findings
 Specialty Starch Operations, MGPI Processing, Inc.

Ref.	Finding	Action Taken	Date Completed	Sup. Doc.
PHA-1002, Revision Date: 3-15-15, Revision 3	Confirm #4 Reactor manway cover replaced to increase pressure rating to 14.5	Completed 2014	03/20/2015	Purchase and SAP notification
PHA-1002, Revision Date: 3-15-15, Revision 3	Add Segregated Control Room to PHA for Reactors, page 16 start	Addition during meeting. Multiple areas as control for employee safety.	3/15/2015	PHA - 1002
PHA-1002, Revision Date: 3-15-15, Revision 3	Assessment for new POC13 Booth Installation, 2014	Reviewed all parameters for new booth	3/15/2015	PHA - 1002
PHA-1002, Revision Date: 3-15-15, Revision 3	Confirm Building Temperature Controls above 35 degrees F.	Visual and confirmation will Operations	03/20/2015	Building Thermostat
PHA-1002, Revision Date: 3-15-15, Revision 3	Confirm PO Sensor tied to deluge system as Control PO-BT, Node 26, page 96	Visual/email showing ladder logic	03/20/2015	Ladder Logic for Controls
PHA-1002, Revision Date: 3-15-15, Revision 3	Confirm Emergency Dump Procedure added to SOPs as Control PO-BT, Node 26, page 96	Confirmation completed and shown to team.	03/20/2015	PSM-024, Revision 12/27/14, Page 81
PHA-1002, Revision Date: 3-15-15, Revision 3	Confirm grounding procedure installed in SOP for unloading PO chemical	Confirmation completed and shown to team.	3/15/2015	PSM-024, Revision 12/27/14, Page 29



PHA-1002, Revision Date: 3-15-15, Revision 3	Confirm PO-BT Pump interlocked with PO-DT Pump (cannot run together)	Ladder Logic shown to team for confirmation.	3/15/2015	Ladder Logic for Controls
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PHA Revalidation for 2015
Specialty Starch Operations, MGPI Processing, Inc.

Ref.	Finding	Action Taken	Date Completed	Sup. Doc.
REV-1002, Revision Date: 3-18-15	Hazards of Process 2.1	Product Manager sign-off	3/20/2015	PHA HAZ-1002, 3-15-15, Rev 3
REV-1002, Revision Date: 3-18-15	Previous Incidents for Catastrophic Release Potential	Management Program 2010. Carried over for 3 years because of CAR denials. New Booth installed in 2014. SOPs, PHA confirmed 3-15-15. Page 31 on PHA	3/20/2015	Previous POCI3 leaks inside booth accumulating in POCI3 Management Program 2010. MRT Meeting Minutes tracking Status of new booth project.
REV-1002, Revision Date: 3-18-15	Confirm Controls listed and assessed annually	Controls also scored for SEMS, in A&Is (annually)	3/20/2015	PHA HAZ-1002, 3-15-15, Rev 3
REV-1002, Revision Date: 3-18-15	Consequences of failure for controls	Consequences also scored for SEMS, in A&Is (annually)	3/20/2015	PHA HAZ-1002, 3-15-15, Rev 3
REV-1002, Revision Date: 3-18-15	Complete PHA with new identifiers	POCI3 booth P&ID updated. SOPs updated in Maintenance and Ops	3/20/2015	P&IDs, PSM027 and PSM 112
REV-1002, Revision Date: 3-18-15	Confirm monthly emergency fire systems check	Product Manager reviewed.	3/20/2015	Simplex Grinnel Monthly Reports
REV-1002, Revision Date: 3-18-15	E Stop verifications for Mod B	Tripped at last Shutdown, and on 3-2-15.	3/20/2015	Visual and active confirmation on 3/2/15
REV-1002, Revision Date: 3-18-15	SOP verification for Emergency Shut Down verification	All listed have Emergency Shutdown Procedures, verified.	3/20/2015	SOPs 11, 17-39



REV-1002, Revision Date: 3-18-15	MOC Process included in Software Package - TrainingMine	Software Package now used to work any MOC for all plant operations.	3/20/2015	TrainingMine
REV-1002, Revision Date: 3-18-15	SOP review annually.	Paperwork showing Operator and Manager Reviews	3/20/2015	SOPs 1-37
REV-1002, Revision Date: 3-18-15	Incident Reviews	Incidents for 2013 - 2015 (injuries, spills, near- misses, etc.) reviewed.	3/20/2015	R/Atchison/Safety/Public/Incident
REV-1002, Revision Date: 3-18-15	Revalidation Sign-off	Joe Hausner Signature	3/20/2015	REV-1002